

Date: Tuesday, 2/6/2007 8:18:43 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 30644	
Estimate Number : 12529	
P.O. Number : N/A	Part Number : D35571
This Issue : 2/6/2007 S.O. No. : N/A	Drawing Number : D3557
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/5/2007 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 28630	Material : N/A
Written By : _____	Due Date : 2/12/2007
Checked & Approved By : <u>07.02.06</u>	Qty: <u>60</u> Um: Each
Comment : Est Rev: A New Issue 06-09-18 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6S125	6061-T6 .125 Sheet
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21058



Comment: Qty.: 0.0343 sf(s)/Unit Total : 0.3430 sf(s)
6061-T6 .125 Sheet
(M6061T6S0125)
Batch: 9103156

SAN 07/02/10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3557
Dwg Rev: _____
Prog Rev: A

****Ensure Grain Direction is Correct****

SAN 07/02/10

2-Deburr if necessary

SAN 07/02/12 60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/02/10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/02/12 60

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
Bend as per Dwg D3557

SAN 07/02/12 60

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/6/2007 8:18:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 30644

Part Number: D35571

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



207-02-14 (60)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HS/4

07-02-19

(60)

8.0

POWDER COATING

POWDER COATING



M103141



(60x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-R/a-m

07/02/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/12/21

(60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5*

07/12/21 (60)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(60)

Comment: FINAL INSPECTION/W/O RELEASE

07/02/22

Job Completion



U 07-02-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

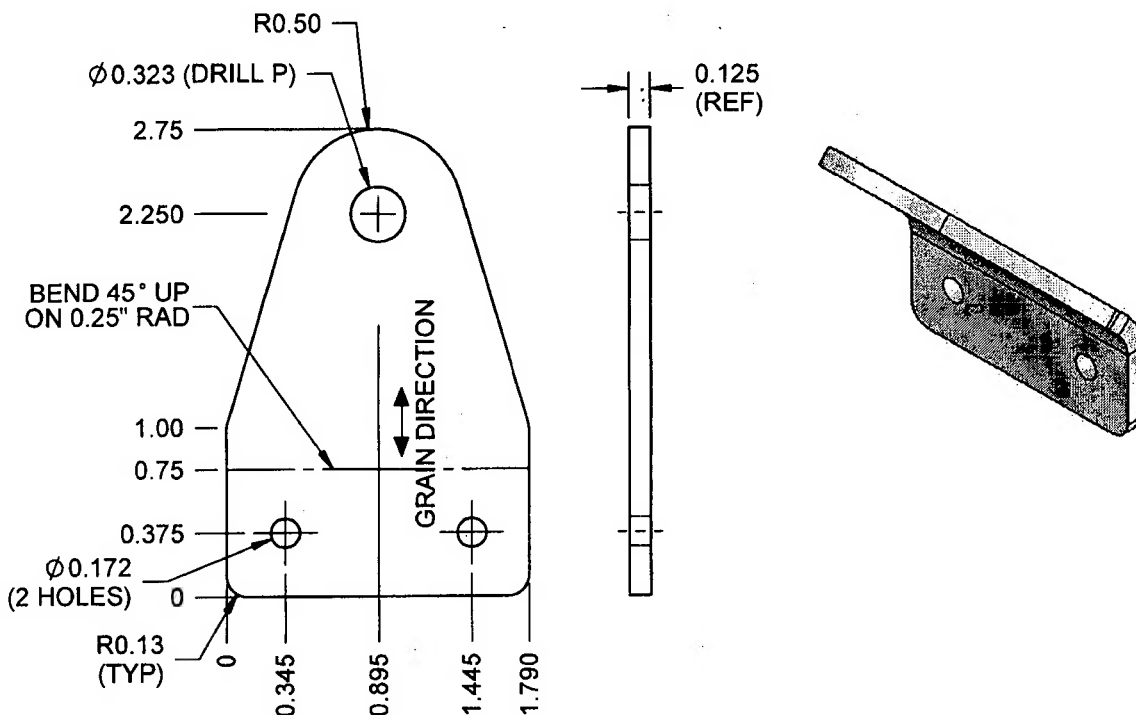
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

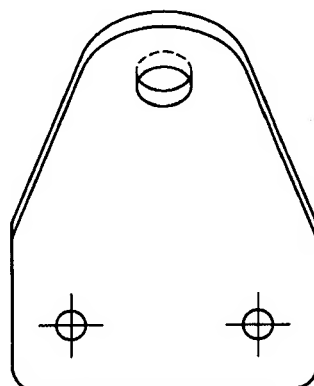
NOTE: Date & initial all entries



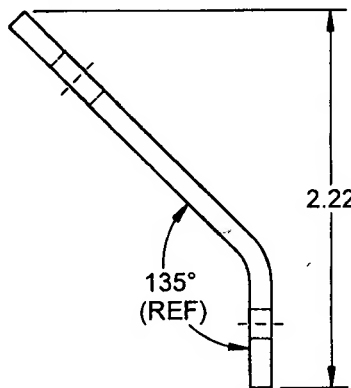
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3557	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE BRACKET	SCALE 1:1	
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3557-1F FLAT PATTERN



D3557-1 BRACKET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *30644*

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER

RELEASED
06-10-13

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DART AEROSPACE LTD		Work Order:	30644
Description:		Part Number:	D35571
Inspection Dwg:	Rev:	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

x Prototype

[illegible]

Measured by:	SAD
Date:	07/02/06

Audited by:	J.F.
Date:	7/02/10

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	